



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBST2120-11
Job Sheet 199074



Part No: RBST2120-11

Job Qty: 2 pcs

Part Name: Primary Seat



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Due Date: 8/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: RBST2100 REV.7 IPP REV:A 18.01.31 NEW ISSUE JFC VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	2 pcs	8/26/19	8/26/19	1.00	0.50	SL-154 - 1	M.L.P 19/08/14
120	QC 2	2 pcs	8/26/19	8/26/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	M.L.P 19/08/14
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S205409



Part: RBST2120-11

Job No: 199074

Serial No/Batch: S205409

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 08/14/19

130 QC 8	2 pcs	8/26/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	8/19-08-14
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Outsource - 12 - Black Oxide	2 pcs	8/26/19		GRO002-VC	8 8/2019-08-19
160 Packaging 2-1 - Receive - B4B	2 pcs	8/26/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	8/ AUG 27 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

170 QC 6	2 pcs	8/26/19	0.00 0.00	Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
180 Packaging 3-1 - Stock - B4B	2 pcs	8/26/19	0.00 0.00	QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	2 pcs	8/26/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
AUG 27 2019 40
9-89

MLL

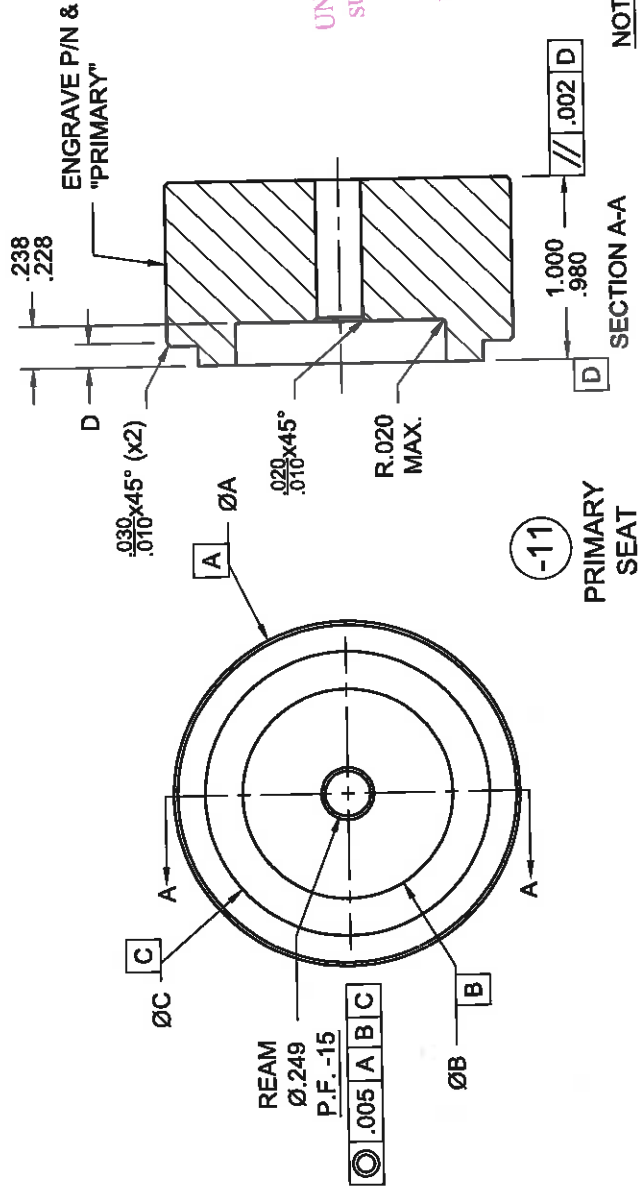
AUG 27 2019 CA138

Part Op 110 - MORI SL-154 LATHE - 1 -Machine as per FOLIO FB797. FOLIO REV: AA DWG REV: 7 2-
Descriptions: Deburr 3-Engrave P/N And / or T/N number as required Using Marktronic engraver as per DWG.
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
150 - -Issue P/O to Groupe Altech; PO 44284 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required
160 - Receive & Inspect for Damage & Mat'l Certs
170 - QC6- All purchased or subcontracted products
180 - Identify as per dwg & Stock Location:
210 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.375	AISI 4140 Quenched &Tempered Steel Round Bar 1.375" Dia.	.2000 ft (.1 ea)	110-SL-154 - 1	5038523
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-4140QT-R1.375	0	15	0
Part Specifications				
Specifications could not be found.				

Plex 8/12/19 10:42 AM Dart.lajeunesse.marie

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INFECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 - .000.	2/1/08	WP DW
2	.48 CHD LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -.11 & -.13. -11 & -13 CHD FROM Ø.247 Ø.248 TO REAM Ø.250.	2/19/08	WP GE
3	REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST. ADDED KST2128 & KST2162 -13 REMOVED 28° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	.48 CHD ROLLER RADIUS FROM .005 - .010, TO .015 - .020, .48 PIN RADIUS FROM .015 MAX., TO .015 MIN. CHD -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CHD T1N FROM KST2100.	11/18/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



NOTES:
1. BREAK ALL SHARP CORNERS (.015/.03).

RED BARN MACHINE

TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; PRIMARY SEAT

DWG NO.	TOOL# (see chart)-11	REV	7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
TOLERANCES ON:			
DECIMALS	FRACTIONS ± 1/32	APPROVED	PERRITT
.XXX ± .005	ANGLES ± 5°	HEAT TREAT	BLACK OXIDE
.XX ± .01		FINISH	USED ON BEARING
.X ± .1		SPEC	SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	1-23-08
		SHEET	7 of 9

TOOL #	ØA + .000 - .030	ØB + .002 - .005	ØC + .002 - .002	D + .002 - .002	MATERIAL
RBST2120	1.360	.875	0	0	4140 Q&T RND. BAR Ø1-3/8 x 1-1/8
RBST2128	1.870	1.139	0	0	4140 Q&T RND. BAR Ø1-7/8 x 1-1/8
RBST2162	1.485	.881	1.183	.053	4140 Q&T RND. BAR Ø1-1/2 x 1-1/8

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Machining ☐ Large Fab ☐
Cross tube ☐ Small Fab ☐ Finishing ☐
Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐
Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐

MRB (QS1042)

Date: _____

Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: _____

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Lead hand / Supervisor

QC / QA Coordinator

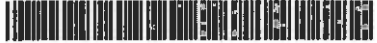


DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044284



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044284
PO Date: 8/19/19
Due Date: 8/27/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
AUG 18 2019

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194529	RBE350A93-3312-03-5	Seat -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/27/19	18 pcs	0 pcs	18 pcs	\$1.35/pcs	\$24.30
2	199074	RBST2120-11	Primary Seat -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	5 pcs	0 pcs	5 pcs	\$1.48/pcs	\$7.40
3	194528	RBE350A93-3312-03-3	Remover / Installer -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/27/19	12 pcs	0 pcs	12 pcs	\$1.35/pcs	\$16.20

X15

AUG 27 2019

S205409

X12

AUG 27 2019

S205279

DP

DP

DAS

40

9-89

Plex 8/20/19 4:25 PM Dart.Guerin.Kimberley

https://www.plexonline.com/dee77787-1439-4966-b0d8-e0624bccd880/Plexus_Control/Report_Viewer_2.asp?rv=u%1E..%2FPurchasing%2FPO_Prin... 1/2



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044284



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194530	RBE350A93-3312-03-7	Washer -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/27/19	18 pcs	0 pcs	18 pcs	\$1.35/pcs	\$24.30
X18 AUG 27 2019 \$206018 DP											
5	194562	RBE350A94-3700-C-03	Bolt -Issue P/O; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	20 pcs	0 pcs	20 pcs	\$1.55/pcs	\$31.00
6	196318	RBE350A93-3303-02-5	Extractor Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	25 pcs	0 pcs	25 pcs	\$1.05/pcs	\$26.25
X25 AUG 27 2019 \$206339 DP											
Grand Total:										\$129.45	

Order Notes

Procurement Quality Clauses

- A005 right of entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable)

- A022 Apical Processing
- A024 process certifications
- A026 certification of material conformance

- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Plex 8/20/19 4:25 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021664-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip
021664-1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
26-Aug-2019		Jigar Patel			POHB044284			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NG Qty	Qté Scrap/	À venir/ Back Order
2	RBST2120-11 Rev.	RBST2120-11 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13924C, CLASS -	OXIDE-BLACK CH	5	5	0	0	40 9-89
3	RBE350A93-3312-03-3 Rev.	RBE350A93-3312-03-3 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13964, CLASS - 1 OR MIL-C-16173 GRADE - 4	OXIDE-BLACK CH	12	12	0	0	0
4	RBE350A93-3312-03-7 Rev.	RBE350A93-3312-03-7 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13964, CLASS - 1 OR MIL-C-16173 GRADE - 4	BLACK-OXIDE CH	18	18	0	0	0
6	RBE350A93-3303-02-5 Rev.	RBE350A93-3303-02-5 OXIDE BLACK [OXIDE BLACK] MIL-C-23942C, CLASS 1	BLACK-OXIDE CH	25	25	0	0	0

RECEIVED
AUG 26 2019
PART AEROSPACE LTD.

RECEIVED
 AUG 26 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.